

Date: Thursday, 3/8/2007 1:19:13 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 31124	
Estimate Number : 12530	
P.O. Number : <u>N/A</u>	Part Number : D35471
This Issue : 3/8/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3547
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30636	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 3/30/2007 Qty: 10 Um: Each
Checked & Approved By : <u>[Signature] 07.03.08</u>	
Comment : Est Rev. New Issue 06-09-18 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S125	2024-T3 .125 sheet
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Comment: Qty.: 0.0557 sf(s)/Unit Total : 0.5565 sf(s)
2024-T3 .125 Sheet
(M2024T3S0125)
Batch: M102087

SAP 07/03/11

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3547
Dwg Rev: A
Prog Rev: A

****Ensure Grain Direction is Correct**** SAD 07/03/11

2-Deburr if necessary SAD 07/03/12

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/03/11

(10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

M 07/03/12

(10)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Bend as per Dwg D3557

SB 07/03/13

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 07/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:19:13 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31124

Part Number: D35471

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



0703-14 (10)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(10X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-H

07/03/14

8.0

POWDER COATING

POWDER COATING



M103706



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-H

07/03/16

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/16 (10) M

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/16 (10) M

M

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/19

Job Completion



u 07/03/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

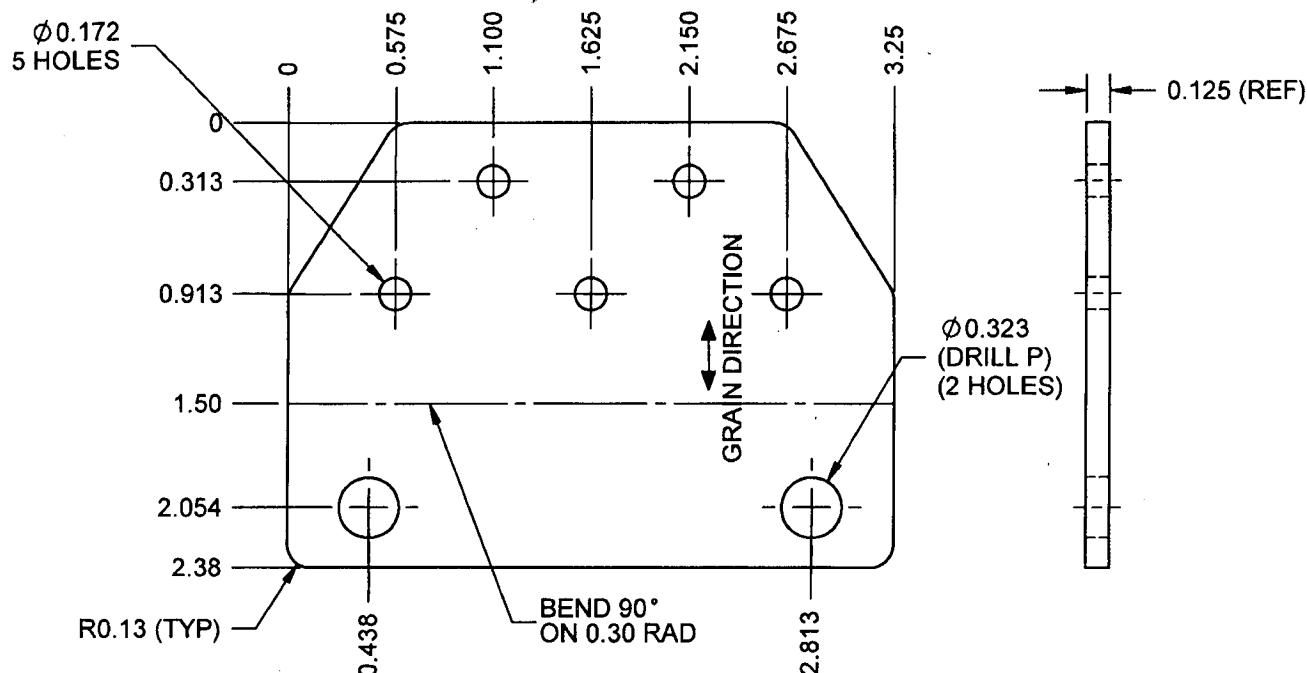
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

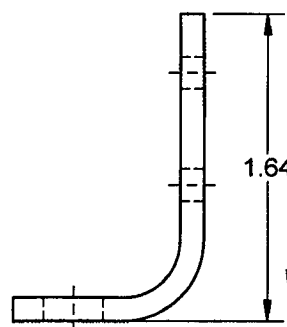
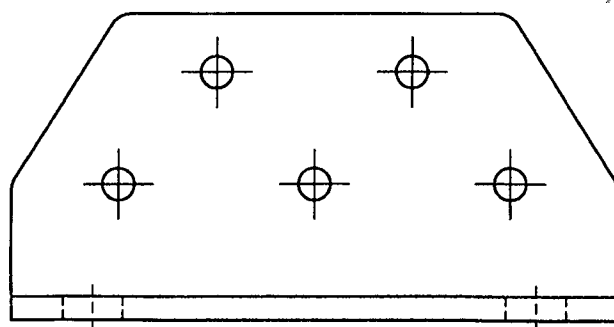


DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3547	REV. A SHEET 1 OF 1
DATE 06.10.06		TITLE BRACKET	SCALE 1:1
REV A	DATE 06.10.06	DESCRIPTION NEW ISSUE	

RELEASED
06.10.13



D3547-1F FLAT PATTERN

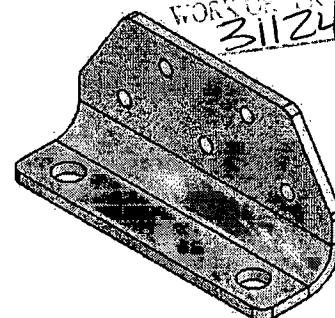


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
31124

D3547-1 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3547-1 USING FINE POINT PERMANENT INK MARKER



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DART AEROSPACE LTD		Work Order: 31124
Description: Bracket		Part Number: D3547-1
Inspection Dwg: D3547-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.313	+/- 0.010	0.316	✓		Vern	
0.913	+/- 0.010	0.916	✓		Vern	
1.50	th					
2.054	+/- 0.010	2.056	✓		Vertical Vern	
2.38	+/- 0.030	2.38	✓		Vern	
0.438	+/- 0.010	0.440	✓		Vern	
2.813	+/- 0.010	2.816	✓		Vern	
0.575	+/- 0.010	0.580	✓		Vertical Vern	
1.100	+/- 0.010	1.105	✓		Vertical Vern	
1.625	+/- 0.010	1.630	✓		Vertical Vern	
2.150	+/- 0.010	2.148	✓		Vertical Vern	
2.675	+/- 0.010	2.680	✓		Vertical Vern	
3.25	+/- 0.030	3.26	✓		Vertical Vern	
Ø 0.172	+/- 0.005 0.001	Ø 0.172	✓		Vern	
Ø 0.323	+/- 0.006 0.001	Ø 0.323	✓		Vern	
0.125	+/- 0.010	0.123	✓		Vern	

Measured by: SAD	Audited by: [Signature]	Prototype Approval: N/A
Date: 07/03/11	Date: 07/03/12	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	